

Date: Friday, 5/9/2008 10:22:30 AM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: NO STEP LABEL		
Job Number	: 39139			Part Number	: D2137		
Estimate Number	: 10160			Drawing Number	: D2137 REV 93.29.06		
P.O. Number	:			Project Number	: N/A		
This Issue	5/9/2008	S.O. No.	:	Drawing Revision	: 93.29.06		
Prsht Rev.	: NC			Material	:		
First Issue	/: /	Type	: PURCHASED PARTS	Due Date	5/16/2008	Qty:	20
Previous Run	: 37068			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JUL 08 509</u>						
Comment	: Est: B 02.02.01 Added step 3 and inspection level 21 SM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>
<b>Comment:</b> PURCHASING Issue P/O <u>6334</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">202105/09</span> Make per Dwg 2137		
2.0	D2137P	Decal - No Step <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) DECAL- NO STEP		
3.0	PACKAGING 1	PACKAGING RESOURCE #1 <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>
<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC5	INSPECT WORK TO CURRENT STEP <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>
<b>Comment:</b> INSPECT WORK TO CURRENT STEP		
5.0	PACKAGING 1	PACKAGING RESOURCE #1 <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">20</span>
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>S113</u> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">28/05/28</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/9/2008 10:22:30 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NO STEP LABEL

Job Number: 39139

Part Number: D2137

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/09 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



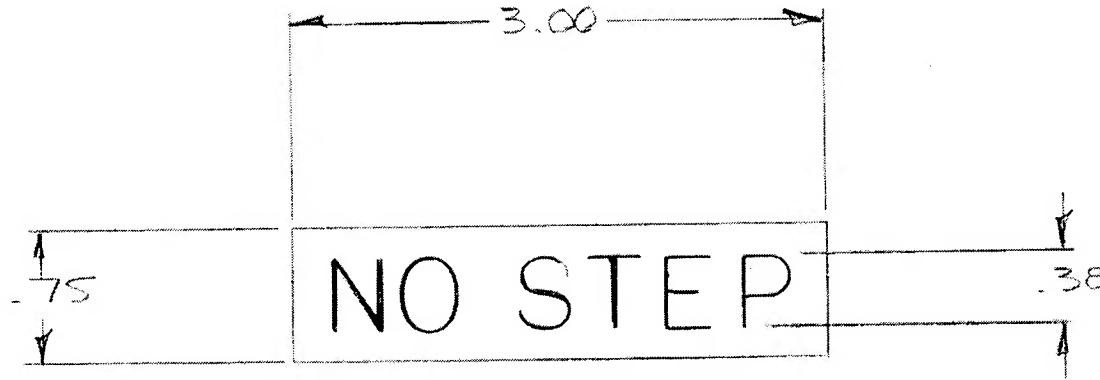
MF 08-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ALTERNATE MATERIAL:

3M 7 MIL MASKING FILM #8522EP

SILVER OR WHITE ON BLACK

~~off 00 09 05~~  
~~CP 00 09 05~~

MATERIAL: 3M POLYESTER

NATURAL (SILVER OR  
WHITE) ON BLACK.  
.003 THICK



LE1201

04/09/05/09  
W/O: 39139

REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN					CONTRACT NO				
APPROVED					DRAWN				
DESCRIPTION	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED				DATE				
OF	GENERAL	LIMITS	0.030	0.010	DESIGN	4/27/09			
CHANGE	1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL .5 - .7742 5. HOLES PER MIL 10387	1. TOLERANCES - .005 MAX 2. ANGLES .0075 3. PARALLELISM .0075 4. LENGTH .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005	0.030	0.010	STRESS				
					CHECKED				
					CURRENT				
	REPORT ALL DISCREPANCIES - DO NOT SCALE		BL-M20470D	BR-M20476D	COOL	04/27/09	REV		
					SCALE	1:1	SHT	1 OF 1	



210 MAIN W.  
HAWKESBURY, ONT. K6A 2H6  
Tel.: 613 632-5449  
Fax: 613 632-9491  
www.studiolettrage.on.ca

## INVOICE / FACTURE

No.: 10240  
DATE: 05/12/2008  
PAGE 1 of 1  
Re: Quote No. 5062

VENDU À:  
SOLD TO:

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario K6A 1K7

LIVRÉ À:  
SHIPPED TO:

Dart Aerospace Ltd  
Hawkesbury, Ontario

P0633

ITEM ARTICLE	QTY QTY	UNIT UNITE	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITE	AMOUNT MONTANT
		20 1	D2137P printing set up  E - GST @ 5% G - GST @ 5%; PST @ 8% GST  PST Exempt: #6122-5207	G E		1.25 50.00	25.00 50.00
GST/TPS: R122278690							
P06334 P06334							TOTAL 8.75

Sold By:

*Mark C. Lusk*



## Product Bulletin 8522

Release F. Effective January 2003  
Black bar in margin indicates a change

# Scotchcal™ Opaque Imaging Media 8522

## Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

## Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
  - For opaque (reflective) graphics
  - Changeable, easy to remove from warranted substrates up to 1 year later
  - Dries quickly after printing so the overlaminates can be applied almost immediately
  - Low slippage paper liner for superior tiling
- Overlaminates:
  - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
  - Available in luster and matte gloss
  - Adhesive allows for heat-assisted or cold-temperature lamination

## Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
  - Graphics for vans, personal vehicles, trucks and buses
  - Novelty posters
  - Retail and point-of-purchase displays
  - Information graphics such as maps and directories
  - Entertainment promotions in museums, zoos, parks, theatres, sports venues
  - Education and presentation graphics

- Legal and courtroom exhibits

- For flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications

## Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

## Compatible Products and Equipment

### Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
  - Epson Archival Inks
- Epson Stylus Pro 10600 printer
  - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
  - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
  - HP83UV Color Ink System

### Overlaminates (required)

- 3M™ Luster Overlaminate 8519 (semi-gloss)
- 3M™ Matte Overlaminate 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

### Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

### Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

## Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical ( $\pm 10^\circ$ ) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

## How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at [www.scotchprint.com](http://scotchprint.com)

## Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

### Warranted Durability

Media 8522 with Overlaminate 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

## Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

## Fabrication

Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

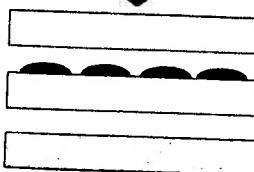
See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

## Graphic Construction Options

### Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.

#### Viewer/Light Source



Overlaminate 8519, 8520  
Adhesive on bottom

Imaging Media 8522  
Image on top; adhesive on bottom  
Opaque Substrate

Note: For the full product names of the 3M products listed on this page, please see page 1.

## Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
  - Original packaging, including plastic wrap
  - Relative humidity of 20% to 80%
  - Temperature of 33° to 104°F (0° to 40°C)
  - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

## Health and Safety



### Caution

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

## Warranty and Limited Remedies

### 3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

*The following is made in lieu of all other express or implied warranties, including any implied warranty of merchantability or fitness for a particular purpose:* We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminate with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

## 3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at [www.scotchprint.com](http://www.scotchprint.com), or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768

International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
<b>Product Bulletins</b>		
3M™ Scotchcal™ Overlaminate 8519 and 8520	8519/8520	4524
<b>Instruction Bulletins</b>		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
<b>Warranties</b>		
Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties)		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

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### Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.

### Commercial Graphics Division

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St. Paul, MN 55133-3220 USA  
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Technical Info: 1-800-328-3908  
Fax 1-651-736-4233

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Fax-on-Demand document: 4506  
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